

Work Order ID 59863

Tuesday, June 15, 2010 10:47:50 AM



Page 1

Item ID: D3852-042

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly

Stop



Start Date: 6/15/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 6/18/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10/06/15 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3852

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- pick D3166-3 to cut D3852-2 rib (RH) as per dwg D3852 using DT9440 jig

2- drill hole (3/16") in D3852-2 using DT9439 jig and open to finish size as per dwg D3852

3- c/sink hole as per dwg

4- remove identification markings

5- deburr

6- weld D3759-1 bushing as per dwg D3852

A/R ER316 S.S. Rod Batch: 1113328

7- grind bushing weld flush as per dwg dwg D3852

8- deburr hole if necessary

10/06/17

SAD 10-06-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59863

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Item ID: D3852-042

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Setup Start



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Start Date: 6/15/2010 Start Qty: 2.00



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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

② 10.06.18

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

10.06.18

② 7042

150

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

SAD
10-06-18

②

W/O:		WORK ORDER CHANGES					
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Tuesday, June 15, 2010 10:47:50 AM

Item ID: D3852-042 Accept  Setup Start 
Revision ID:
Item Name: Rib Assembly Stop 
Start Date: 6/15/2010 Start Qty: 2.00  Cust Item ID:
Required Date: 6/18/2010 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

10/06/21 
mf
10-6-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, June 15, 2010 10:47:53 AM

Page 1

Work Order ID: 59863

Parent Item: D3852-042

Parent Item Name: Rib Assembly



Start Date: 6/15/2010

Required Date: 6/18/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-02 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3166-3		Manufactured	No			100	Each	11.0528	0.18	0.378947			
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Basket Hoop



SAD 10-06-17

Location	Loc Qty	Loc Code
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WA	11.05282105	
55697	2.1053E-05	
56426	0.0528	
57504	5	
59266	6	

0.37947

D3759-1		Manufactured	No			100	Each	16.0000	1	2			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



Bushing



B59419 (2) NY 10/06/17

Location	Loc Qty	Loc Code
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WA	16	
54072	9	
58672	7	

W/O:		WORK ORDER CHANGES					
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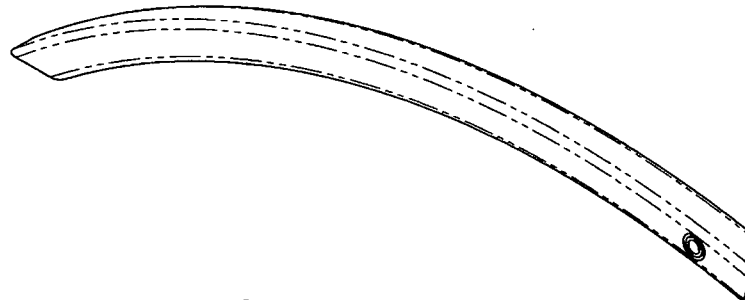
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3852-041	RIB ASSEMBLY
2		X	D3852-042	RIB ASSEMBLY
3	1	1	D3759-1	BUSHING
4	1		D3852-1	RIB
5		1	D3852-2	RIB



D3852-041 RIB ASSEMBLY



D3852-042 RIB ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 59863
PD10-6-15

RELEASE
08/11/07 MP

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.83 lbs EACH
 - 8) WELDING: PER QSI 004

A	NEW ISSUE	MB	08.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.07		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3852** REV. A
SHEET 1 OF 3
TITLE **RIB ASSEMBLY** SCALE NTS

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8 7 6 5 4 3 2 1

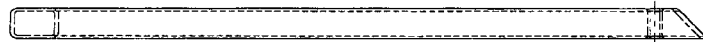
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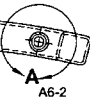
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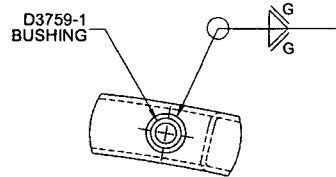
NOTE: Date & initial all entries



D3852-1
RIB



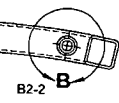
D3852-041 RIB ASSEMBLY



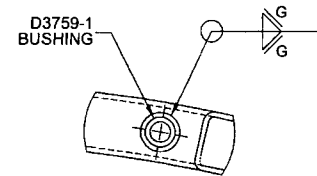
DETAIL A
SCALE 2X C5-2



D3852-2
RIB



D3852-042 RIB ASSEMBLY



DETAIL B
SCALE 2X C2-2

W/0 59863

RELEASED
08/11/07

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>125</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>125</i>	D3852	SHEET 2 OF 3
APPROVED	<i>125</i>	TITLE	SCALE
DE APPR.	<i>125</i>	RIB ASSEMBLY	NTS
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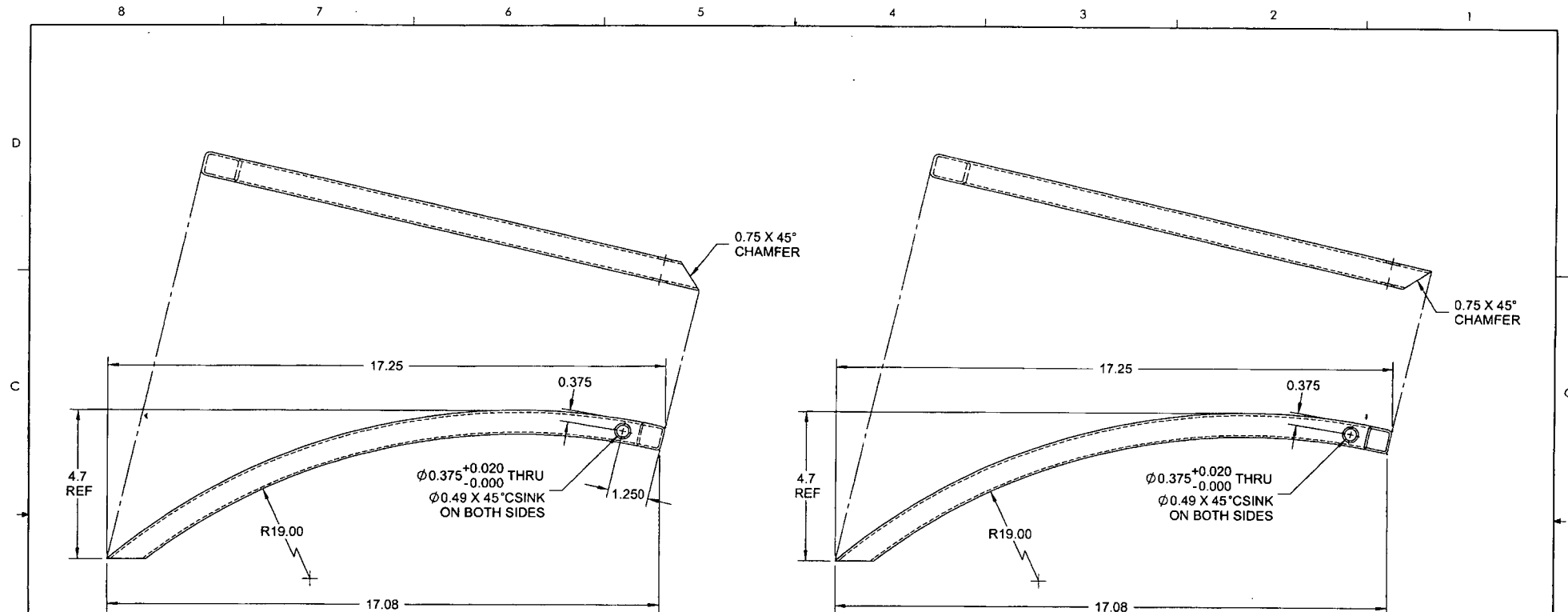
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D3852-1 RIB

D3852-2 RIB

w/o 59863

RELEASED
08/11/2007

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.82 lbs EACH

DESIGN		DART AEROSPACE LTD
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CHECKED		DRAWING NO. D3852 REV. A
MFG. APPR.		SHEET 3 OF 3
APPROVED		TITLE RIB ASSEMBLY SCALE
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